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D412-698-011
Job Sheet 186027



Part No: D412-698-011

Job Qty: 1 ea

Part Name: Cabin Door Roller LH Aluminum Door



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/8/18

Job Tracking No:

Due Date: 11/22/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: IIN-D412-698 REV.G IPP Rev:C 04.02.26 Change Qty of D3121-141 & remove D3121-145 from Step 1,3
KJ/DS IPP Rev:D 08-01-28 change to rev D ECN 1104 DD

Ship Via:

658L

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/22/18	0.00	0.00	Start Up Stores/Pkg-2		NOV 21 2018
110	Packaging	1 pcs		11/22/18	0.00	0.00	Packaging1-4		NOV 21 2018
120	QC	1 pcs		11/22/18	0.00	0.00	QC4		
130	Packaging	1 pcs		11/22/18	0.00	0.00	Packaging3-2		DAS
135	DC	1 pcs		11/22/18	0.00	0.00	DC		21 NOV 21 2018
140	QC21-FG	1 Ea		11/22/18	0.00	0.00	QC21		3-89

Part Op 110 - Pick Kit

Descriptions: 120 - QC4- 100% Inspect kits for completeness

130 - Identify and pack for shipping as per PPP D412-698-011 Location:FG034

135 - Photocopy bluefile and create labels per PPP D412-698-011 CHG003

140 - QC21- Final Inspection - Work Order Release

DAS NOV 21 2018
21
3-89

fg 034

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3121-141	Bracket Assembly	3 Ea (3 ea)	90-Start up Operation	5116152
D3121-143	Bracket Assembly	1 Ea (1 ea)	90-Start up Operation	5103728
D3137-043	Bracket Assembly	1 Ea (1 ea)	90-Start up Operation	5117179
D3183-043	Bracket Assembly	1 Ea (1 ea)	90-Start up Operation	5121684
D3199-1	Bracket	9 Ea (9 ea)	90-Start up Operation	5059065
D3202-1	Cover	1 Ea (1 ea)	90-Start up Operation	5025333

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3121-141	3	4	0
	D3121-143	1	6	0
	D3137-043	1	4	0
	D3183-043	1	8	0
	D3199-1	9	74	0
	D3202-1	1	14	0

Part Specifications

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval			
Description Work Order Deviation		Disposition		Completed By			
DART Aerospace, 1270 Aberdeen Street, 12701 Herndon, VA 22060 TEL: 703 552-5000 FAX: 703 552-5001 E-MAIL: sales@dartaero.com www.dartaerospace.com Container No: S129832 Part: D412-698-011 Job No: 186027 Serial No/ Batch: S129832 Revision: G Inspector: TC STC SH92-43 Issue Base FA-826 SR0-1446NY 08102108, ERSA S				Lead hand / Supervisor Approval Verification			
				QC / QA Coordinator Approval			
Re-verification ☐ rator ☐ t/Setup ☐ esting ☐ mation ☐ rovement ☐ ovement ☐		FAULT CATEGORY					
Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
Manufacturing Process ☐ Past Due ☐		OTHER : _____					

Specifications could not be found.

Plex 11/8/18 11:26 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

REFERENCE ONLY

6.0 PARTS LIST – CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Qty -027	Qty -028	Part Number	Description
X								D412-698-011	CABIN DOOR ROLLER KIT, LH
	X							D412-698-012	CABIN DOOR ROLLER KIT, RH
		X						D412-698-013	DOOR HANDLE KIT
			X					D412-698-017	REPLACEMENT DOOR TRACK KIT
				X				D412-698-019	BEARING OVERHAUL KIT
					X			D412-698-021	REPLACEMENT SHIM KIT
						X		D412-689-027	BRACKET KIT, LH (ALUMINUM DOORS)
							X	D412-689-028	BRACKET KIT, RH (ALUMINUM DOORS)
3	3							D3121-141	BRACKET ASSEMBLY
1								D3121-143	BRACKET ASSEMBLY
	1							D3121-144	BRACKET ASSEMBLY
1	1							D3137-043	BRACKET ASSEMBLY
1								D3183-043	BRACKET ASSEMBLY
	1							D3183-044	BRACKET ASSEMBLY
9	9		9					D3199-1	BRACKET
						1		D3199-3	FORWARD BRACKET, LH
							1	D3199-4	FORWARD BRACKET, RH
1	1		1					D3202-1	COVER
		4						D3203-1	HANDLE
		1						D3220-041	DOUBLER
		1						D3220-042	DOUBLER
		2						D3220-3	DOUBLER
				7				D3121-21	BOLT
				5				D3121-241	BEARING ASSEMBLY
				1				D3137-3	GUIDE
				1				D3137-5	WASHER
				2				D3183-045	BEARING ASSEMBLY
					3			D3238-1	SHIM
					1			D3238-3	SHIM
					2			D3238-5	SHIM
					6			D3238-11	SHIM
					2			D3238-13	SHIM
					4			D3238-15	SHIM
		8						NAS1149D0463J	WASHER (AN960JD416L)
		8						MS21042L4	NUT (OR MS21042-4)
		16						MS24694-S98	SCREW
				1				MS24694-S101	SCREW

REFERENCE ONLY

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Revision: G

Date: 17.11.23

YJ

A

REFERENCE ONE